

# Work Order ID 52720

October 9, 2009 11:22:18 AM



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Item ID: D044-717-011

Revision ID: N/A

Item Name: Cold Weather Baffle

Start Date: 10/09/09 Start Qty: 4.00

Required Date: 10/13/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D044-717-011CHG001

8/11/30

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

9/11/30 (425)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

2) 8/11/30

(74)

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Item ID: D044-717-011

Revision ID: N/A

Item Name: Cold Weather Baffle

Accept



Setup Start



Stop



Start Date: 10/09/09 Start Qty: 4.00

Required Date: 10/13/09 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP D044-717-011

Location: B

PPP Rev: B

9/11/30

80 (40)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/12/01 HJ

Pl 09121

(4)

# Picklist Print

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Work Order ID: 52720

Parent Item: D044-717-011RevN/A

Parent Item Name: Cold Weather Baffle


Comments:

Start Date: 10/09/09

Required Date: 10/13/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3276-041RevB		Manufactured	No			110	Each	4.0000	4.0000			
												
Baffle Assembly LH												


Warehouse Loc Qty Loc Code


Location

Main Warehouse

ST

44266

D3276-042RevB		Manufactured	No			110	Each	0.0000	4.0000			
												
Baffle Assembly RH												

D3383-1RevA		Manufactured	No			110	Each	1.0000	4.0000			
												
Placard												


Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

39690

AN526C1032R7		Purchased	No			110	Each	34.0000	32.0000			
												
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

104394

110715

34

4

30

9/11/30

SP

44266

52374

9/11/30 SP

52723

9/11/30

SP

1113096

9/11/30

SP

1x 30x SP

# Picklist Print

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Work Order ID: 52720

Parent Item: D044-717-011RevN/A

Parent Item Name: Cold Weather Baffle

Comments:

Start Date: 10/09/09

Required Date: 10/13/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-4	x16	Purchased	No			110	Each	8,085.000	64.0000			

RIVET

9/11/30

SL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8085

104374

4085

110398

4000

110

Each

425.0000

8x

32.0000

64x8

9/11/30

40

SL

MS21059L3

Nut Plate

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

425

109962

11

111925

414

32x50

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Shop Packet Print

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## 2.0 GENERAL NOTES

### COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

### CONTINUING AIRWORTHINESS

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-717. Refer to the Aircraft Maintenance Manual for standard shop practices not referred to in these Installation Instructions.

## 3.0 INSTALLATION PROCEDURE

The Dart D044-717-011 Cold Weather Baffle Kit should be installed as follows:

- 3.1 Temporarily locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 1. Transfer drill the 4 holes to the aircraft and enlarge to  $\varnothing 0.203$ " (5.20mm). Ensure minimum edge distance of 0.300" from center of hole to edge of opening.
- 3.2 Drill  $\varnothing 0.098$ " holes for MS20426AD3-4 rivets that will be used to install the MS21059L3 nutplates. C'sink  $\varnothing 0.179$ "x100° (4.55mm x100°).
- 3.3 Deburr all drilled/c'sink holes and touch-up with primer per the Aircraft Maintenance Manual.
- 3.4 Install MS21059L3 nutplates on a/c holes using MS20426AD3-4 rivets. Install the D3276-041 Baffle Assembly using AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 3.5 Repeat installation for RH side using D3276-042 Baffle Assembly.
- 3.6 Install D3383-1 Placard in full view of the pilot.

## 4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kG

## 5.0 PARTS LIST

Qty -011	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE